



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3639-1
Job Sheet 179720



Part No: D3639-1

Job Qty: 6 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/04
100	Waterjet	6 pcs	7/18/18	7/18/18	0.00	0.46	Waterjet1		SC 18/07/04
110	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Waterjet-2		SC 18/07/04
120	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC8-3		38
130	Brake NC	6 pcs	7/18/18	7/18/18	0.06	0.28	Brake NC 1		9-89 DAS 38
140	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs	7/18/18	7/18/18	0.00	0.37	HandFinish1		SA 18-07-23 38
160	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC3		38
170	Packaging	6 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1	Stops 89	JUL 24 2018
180	QC21-SA	6 Ea	7/18/18	7/18/18	0.00	0.00	QC21		DAS 21 9-89 JUL 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.4340 sf (.239 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	1	83	0

Part Specifications

Specifications could not be found.

Plex 6/21/18 7:27 AM Dart.lajeunesse.marie

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I

DART AEROSPACE LTD		Work Order: 179720
Description: Doubler		Part Number: D3639-1
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	Ø0.625	1		VSC-01	
Ø0.191	+0.005/-0.001	Ø0.191	1			
Ø0.098	+0.004/-0.001	Ø0.098	1			
0.69	+/-0.030	0.70	1			
1.59	+/-0.030	1.60	1			
2.49	+/-0.030	2.50	1			
3.39	+/-0.030	3.397	1			
3.990	+/-0.010	3.997	1			
4.990	+/-0.010	4.998	1			
5.19	+/-0.030	5.20	1			
6.99	+/-0.030	6.998	1			
8.64	+/-0.030	8.643	1			
0.45	+/-0.030	0.458	1			
0.710	+/-0.010	0.712	1			
2.000	+/-0.010	2.001	1			
2.75	+/-0.030	2.757	1			
3.55	+/-0.030	3.556	1			
4.00	+/-0.030	4.01	1			
2.000	+/-0.010	2.002	1			
2.590	+/-0.010	2.594	1			

Measured by: SC	Audited by: DAS 38 9-89	Prototype Approval:	N/A
Date: 18/07/04	Date: JUL 04 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS